

# Work Order ID 72107

Tuesday, July 19, 2011 11:16:05 AM



Page 1

Item ID: D4073-1

Accept



Setup Start



Revision ID:

Item Name: Door Hinge

Stop



Start Date: 7/19/2011 Start Qty: 1200



Cust Item ID:

Required Date: 7/25/2011 Req'd Qty: 1200

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-07-19

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4073

B

100

Cut blanks as per folio

0.00



Bandsaw

Memo

0.00

cut 11/09/26

36 0

Jeaspa Bandsaw

cut blank 4.563" long

105

0.00



HAAS 1

Memo

0.00

cut 11/09/27

36 0

HAAS CNC vertical machine #1

Mill as per Dwg an Folio FA939

Dwg Rev: 3

Folio Rev: AA

Deburr

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 72107**

Tuesday, July 19, 2011 11:16:05 AM

Page 2

Item ID: D4073-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Door Hinge

Start Date: 7/19/2011 Start Qty: 12.00

Cust Item ID:

Required Date: 7/25/2011 Req'd Qty: 12.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing



and 11/09/27

36 0

S.D. 11/09/27

36 0

36 11-9-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 72107

Tuesday, July 19, 2011 11:16:06 AM



Page 3

Item ID: D4073-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Door Hinge

Start Date: 7/19/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 7/25/2011 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Start Time: 3:45



Powdercoat

Memo

0.00

Temp: 320°F

Powder Coating

W118434

Finish Time: 4:15

36x8 M-L 11/10/03

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

36 x 8 M-L 11/10/03  
COUNTED

Quality Control

180

Identify as per dwg & Stock Location: St 120

0.00



Packaging

Memo

0.00

SP 11-10-4

Packaging

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 72107**

Tuesday, July 19, 2011 11:16:06 AM



Page 4

Item ID: D4073-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Door Hinge

Start Date: 7/19/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 7/25/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/10/11  
ms  
11-104

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Tuesday, July 19, 2011 11:16:12 AM

Page 1

Work Order ID: 72107

Parent Item: D4073-1

Parent Item Name: Door Hinge



Start Date: 7/19/2011

Required Date: 7/25/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV:A NEW ISSUE 10-06-08 JLM VERIFIED BY:DD IPP  
REV:B DRAWING REV. CHANGE AS PER ECN 11-598 11-07-05 JFS  
VERIFIED BY:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X01.25 0		Purchased	No			100	f	15.8176	0.38	4.8			



6061-T6 Bar 2.00 x 1.25



Location	Loc Qty	Loc Code
MAT010	15.81763158	
114899	4.15263158	
116623	2.15	
118008	9.515	

M 118641 X 14.364

and 11/09/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 72107
<b>Description:</b> door hinge		<b>Part Number:</b> B 4073-1
<b>Inspection Dwg:</b> B4073	<b>Rev:</b> B	<b>Page 1 of 1</b>

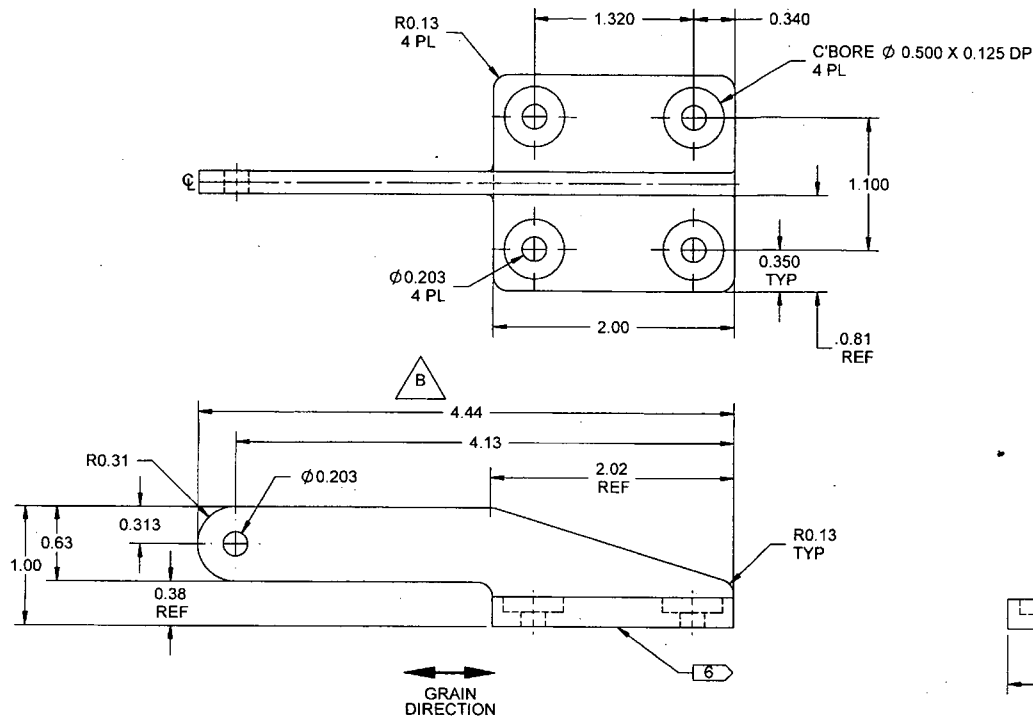
### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.13	+ -0.020	6.13	✓		R-G	
1.320	+ -0.010	1.320	✓		vern. SL-3	
340	+ -0.010	340	✓			
500x.125 deep	+ -0.010	504x.124	✓			
1.100	+ -0.010	1.100	✓			
.81	+ -0.030	.804	✓			
350	+ -0.010	350	✓			
2.00	+ -0.030	2.002	✓			
8.203	+0.005 -0.001	8.203	✓			
4.44	+ -0.030	4.436	✓			
4.13	+ -0.030	4.127	✓		H-G	
313	+ -0.010	313	✓			
6.31	+ -0.030	6.311	✓			
.63	+ -0.030	.632	✓			
1.00	+ -0.030	.998	✓			
38	+ -0.030	37.4	✓			
190	+ -0.010	192	✓			
1.80	+ -0.030	1.800	✓			
6.13	+ -0.030	6.125	✓			
25	+ -0.030	24.8	✓			

<b>Measured by:</b> SL	<b>Audited by:</b> B.A	<b>Preliminary Approval:</b>
<b>Date:</b> 11-09-26	<b>Date:</b> 11/09/27	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15



**D4073-1 DOOR HINGE**

SHO...  
RETURN TO  
ENGINEERING  
UNCONTROLLED  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 72107

**RELEASED**  
2011-06-30  
WJP

**NOTES:**

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR  
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)  
OR ASTM B211 OR ASTM B221  
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.12 lbs

B	4.44 WAS 3.75; 4.13 WAS 3.44 (ZN C6-1)	RF	11.05.02
A	NEW ISSUE	RF	10.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN	RF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.05.02		
<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA DRAWING NO. <b>D4073</b> TITLE <b>DOOR HINGE</b> REV. B SHEET 1 OF 2 SCALE NTS <small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC.            THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS            NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT            WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>			

W/O:		WORK ORDER CHANGES						
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries